

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010798**Date Inspected:** 16-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER/ OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

HEAVY DOCK

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040343 performing Flux Cored Arc Welding process for the weld SSD1-A111B/H-15 located on PCMK the stiffener between skin C and skin D of South tower lift 1. ZPMC QC Mr. Qin Wen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U4A-F-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057869 performing Flux Cored Arc Welding process for the weld SSD1-SA40B/E-07 located on PCMK the weld between P357 and P174 at skin E of south tower lift 1. ZPMC QC Mr. Qin Wen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

NORTH TOWER LIFT # 1

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201825 performing Flux Cored Arc Welding process for the weld NSD1-A112-B/H-44 located on PCMK the weld between skin E and base plate of North tower lift 1. ZPMC QC Mr. Qin Wen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220069 performing Flux Cored Arc Welding process for the weld SP309-001-043 located on PCMK hold back weld between T stiffener and side panel (bike path side) at splice weld between OBG segment 6BE and 6CE. ZPMC QC Mr. Song Hui monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049769 performing Shielded Metal Arc Welding process for the weld OBE6-002 located on PCMK deck panel splice weld between OBG segment 6AE and 6BE. ZPMC QC Mr. Song Hui monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair.

CROSS BEAM # 5

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220063 performing Flux Cored Arc Welding process for the weld SSD11A-PP039-172 located on PCMK Cross beam 5. ZPMC QC Mr. Zhang Ha Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for the weld SSD12B-PP39-153 located on PCMK Cross beam 5. ZPMC QC Mr. Zhang Ha Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG SEGMENT 6 BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for the weld SEG029C-032 located on PCMK Short Longitudinal Diaphragm at PP41(cross beam side) to floor beam. ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials

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for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer